TO REUB B DRAWING 5/14/14/27

Work Order ID 119301

May-15-14 12:36:02 PM

119301

~~PRELIMINARY ISSUE~~

Item ID: D2262-041 **Accept** *N900040100* **Setup Start** *NS1*

Revision ID: ~~PRELIM~~ Release **Stop** *NS2*

Item Name: Short Arm Assembly

Start Date: 5/15/14 **Start Qty:** 1.00 *1*

Required Date: 5/15/14 **Req'd Qty:** 1.00 *1*

Reference:

Cust Item ID:

Customer:

Run Start *NR1*

Stop *NR2*

Approvals: **Process Plan:** MJ **Date:** 14-05-15 **Tooling:** _____ **Date:** _____

QC: _____ **Date:** _____ **SPC (Y/N):** _____ **Date:** _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	**Revision Nbr**								
D2262	~~PB1~~ Rev 3	5/14/8/27							
100		0.00							
100	NC BRAKE					1			FF 14-05-25
Brake NC	**Memo**	0.00							
Brake NC	CUT AND PUNCH TUBE AS PER DWG DEBURR AND REMOVE MARKING								
110	QC5- Inspect part completeness to step on W/O	0.00							DAS 27 9-89
110						Inspect as			
QC	**Memo**	0.00							
Quality Control						Per Dwg PB1			
120	Black Sandtex(Ref:4.3.5.7) per QSI005 4.3	0.00							
120	M 176 878.					1 of	14-5-20		DAS 34 9-89
Powdercoat	**Memo**	0.00							
Powder Coating	START TIME: 10:40 OVEN TEMPERATURE: 380 FINISH TIME: 11.10.								

Work Order ID 119301

119301

May-15-14 12:36:02 PM

Item ID: D2262-041 **Accept** *N9000040100* **Setup Start** *NS1*
Revision ID: PRELIM **Stop** *NS2*
Item Name: Short Arm Assembly

Start Date: 5/15/14 **Start Qty:** 1.00 *1*
Required Date: 5/15/14 **Req'd Qty:** 1.00 *1*
Reference:

Cust Item ID:
Customer:

Run Start *NR1*
Stop *NR2*

Approvals: **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____
QC: _____ **Date:** _____ **SPC (Y/N):** _____ **Date:** _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130	QC3- Inspect Part Finish	0.00			DAS 30				
130						1			14/06/04
QC	**Memo**	0.00							
Quality Control									
140		0.00							
140	Small Fab								FF
Small Fab						1			14-06-04
Small Fab	**Memo** Assemble as per dwg D2262	0.00							
150	QC5- Inspect part completeness to step on W/O	0.00							
150						(1)	14-06-04		6 DAS
QC	**Memo**	0.00							
Quality Control									

Item ID: D2262-041 **Accept** *N9000040100* **Setup Start** *NS1*
Revision ID: PRELIM **Stop** *NS2*
Item Name: Short Arm Assembly

Start Date: 5/15/14 **Start Qty:** 1.00 *1*
Required Date: 5/15/14 **Req'd Qty:** 1.00 *1*
Reference:

Cust Item ID:
Customer:

Approvals: **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____
QC: _____ **Date:** _____ **SPC (Y/N):** _____ **Date:** _____

Run Start *NR1*
Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
160	Identify as per dwg & Stock Location:_____	0.00							
160									
Packaging	**Memo**	0.00							
Packaging									
170	QC21- Final Inspection - Work Order Release	0.00							
170									
QC	**Memo**	0.00							
Quality Control									

SHIP TO DAVID S.

4/9/9

TIVE RECALL
TIVE 14/05/5 AUTH
SED 5 DATE 14/05/27
to Rev B Dwg ok

Picklist Print

May-15-14 12:36:06 PM

Work Order ID: 119301 *1193O1*

Parent Item: D2262-041 *D2262-041*

Parent Item Name: Short Arm Assembly

Start Date: 5/15/14 **Required Date:** 5/15/14

Start Qty: 1.00 **Required Qty:** 1.00

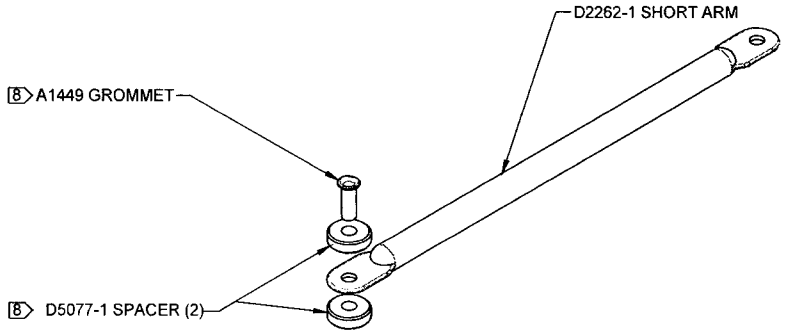
Comments: IPP REV:A 14.05.13 NEW ISSUE DD VERF:JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M304TR0.500W.035		Purchased	No			100	f	313.4121	0.9	1			
M304TR0.500W.035									**			FF 14-05-15	
304 RD Tube .500 x .035W													
				Location			**Loc Qty**		**Loc Code**				
				MAT017			313.4121						
					125513		0.0998						
					m126922		3						
					~~m128084~~		70.3123			1			
					m128495		120						
					m128833		120						
A1449		Purchased	No			140	Each	1,171.000	1	1			
A1449									**			FF 14-06-04	
Grommet													
				Location			**Loc Qty**		**Loc Code**				
				ST278	~~119304~~		1171			2			
					1487		1171			~~3~~			
D5077-1		Manufactured	No			140	Each	0.0000	2	2			
D5077-1									**			FF 14-06-04	
Spacer													

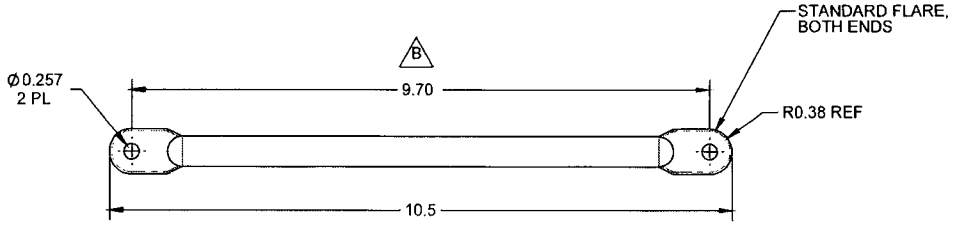
119735

ITEM	QTY -041	P/N	DESCRIPTION
	X	D2262-041	SHORT ARM ASSY
1	1	D2262-1	SHORT ARM
2	2	D5077-1	SPACER
3	1	A1449	GROMMET

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 119301 MC
14-05-15



D2262-041 SHORT ARM ASSY



D2262-1 SHORT ARM

NOTES:
1) MATERIAL: D2262-1: AISI 304/316 SS SEAMLESS ROUND TUBING PER ASTM A213 OR ASME SA213 OR ASTM A269
1/2" OD X 0.035" WALL (REF DART SPEC M304TR0.500W.035)
2) FINISH: D2262-1: POWDER COAT "BLACK SANDTEX" (4.3.5.7) PER DART QSI 005 4.3
D2262-041: NONE
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
6) IDENTIFICATION: IDENTIFY ASSEMBLY WITH DART P/N "D2262-041" USING A REMOVABLE TAG PER DART QSI 044 6.6
7) WEIGHT: 0.07 lbs
8) ASSEMBLE D5077-1 SPACERS (QTY 2), D2262-1 SHORT ARM AND A1449 GROMMET AS SHOWN AND SWAGE GROMMET.

REV.	DESCRIPTION	BY	DATE
B	RE-FORMAT DRAWING, ADD HOLE-TO-HOLE DIMENSION	DB	14.03.12
A	NEW ISSUE	MC	94.08.10

APPROVED

DESIGN	MC	DART AEROSPACE LTD	
DRAWN	DB	HAWKESBURY, ONTARIO, CANADA	
CHECKED	AP	DRAWING NO. D2262	REV. B
MFG. APPR.	JLM		SHEET 1 OF 1
APPROVED	MP	TITLE SHORT ARM ASSY	SCALE NTS
DE APPR.	DS		
DATE	14.03.12		

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DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE

DART AEROSPACE

QA Closed: Date: Work Order update only ☐

Work Order: _____

Part No. _____

NCR No. _____

DISPOSITION

Rework ☐
Scrap ☐
Use-as-is ☐
Suspected Unapproved ☐

AGAINST DEPARTMENT/PROCESS

Skid-tube ☐ Crosstube ☐ Water Jet ☐ Engineering ☐
Machining ☐ Small Fab ☐ Prod. Eng. Coor. ☐ Quality ☐
Thermoforming ☐ Finishing ☐ Rec/Store/Packaging ☐ Other ☐
Large Fab ☐ Composite ☐ Supplier ☐ ☐

Root Cause		Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Design	☐									
Doc/Data	☐									
Equip/Tooling	☐									
Handling/Pre	☐									
Material	☐									
Operator	☐									
Offset/Setup	☐									
Process	☐									
Supplier	☐									
Training	☐									
Transport	☐									
Unapproved	☐									

FAULT CATEGORY

Landing Gear

☐ Bending
☐ Centre Not Concentric
☐ Cracks
☐ Crimp/Kink/Ripple/Wave
☐ Cuffs
☐ Crushing
☐ Heat Treat
☐ Inspection Strip in Tube
☐ Marks/Chatter
☐ Turning Sequence
☐ Wave/Twist in Tube

General

☐ Bend
☐ BOM/Route
☐ Broken/Damage/Defect
☐ Burrs
☐ Contamination
☐ Countersink
☐ Cut Too Short
☐ Drawing
☐ Drill Holes
☐ Finish
☐ Fit/Function

☐ Folio/Program
☐ Grain
☐ Hardware
☐ Inspection Incomplete/Unqualified
☐ Instructions Incomplete/Unclear
☐ Misaligned/off center
☐ Mislabeled
☐ Misread
☐ Off-set
☐ Out of Calibration
☐ Out of Sequence

☐ Outside Dimensions
☐ Over/Under tolerance
☐ Part Incorrect
☐ Part Lost/Missing
☐ Part Moved
☐ Positioned Wrong
☐ Power Loss/Surge

☐ Pressure/Forced
☐ Set-up
☐ Temperature/Cure
☐ Weld
☐ Wrong Stock Pulled

☐ Other

DART AEROSPACE LTD

Description: Short Arm Ass Work Order: 119301

Inspection Drawing: D2262 Rev: PB1 Part Number: D2262-041

INSPECTION SHEET

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
9.70	±0.030	9.70	✓		SFab-07	
10.50	±0.030	10.50	✓		SFab-07	

Measured by:	Checked By: DAS 36 8-89	QC inspector: DAS 27 9-89	Engineering Approval *(if necessary*
FF			
Date 14-05-15	Date 14/05/16	Date 14/5/16	Date

Receiving Report

Date: 14/01/08

Batch No: M128084

Supplier: MARMON

Dart P/O: 22782

Packing Slip: Yes ✓ No
Invoice: Yes ___ No ~
Receipt: Cash ___ Cr

Release Note Attached: Yes ✓ No ___ N/A ___
Waybill Attached: Yes ~ No ___
Shipment Complete: Yes ✓ No ___ N/A ___
QC6 Inspection ___ N/A ___
Work Order ___ N/A ✓

Discrepancies

Part Number	Description	Quantity Ordered	Quantity Received	Quantity Returned	Quantity Short	Comments

Initials of receiver (if shipment OK) Level 12 ✓

Production/Admin: 14.1.08
Date Received/Costing ___
Initial ___

Location ___

Purchase Order Receipt Listing

Thursday, January 30, 2014 10:41:16 AM

All amounts are calculated in domestic currency.

All Vendors PO ID po22782 All Receipt Dates All Line Item Types
All Item ID/GL/WOs All Rec. Employees All Currencies
Grouped by Vendor ID

Purchase Order ID/ Curr Type	Line Nbr/ Insp Req	Project ID	Reference/ Description/ Cert Std	PO U/M / Stock U/M	Required Date Required Qty	Recv Date/ Recv Emp	Recv Qty (PO U/M)	Cost Per Unit/ Recv Value	Inspected Qty/ Rejected Qty (PO U/M)	MRB Qty/ MRB Reject Qty	Book Amt
VendorID\Vendor Name		**VC-MAR001**	**Marmon/Keystone Canada Ltd.**								
PO22782	1		M6061T6T1.000W.065	f	1/29/2014	1/28/2014	84.0000	$3.48	0.0000	0	$292.21
CAD	No		6061T6 RD TUBE 1.00 x .065w	f	84.0000	DESJ02		$292.21	0.0000	0	
			M128084								
	2		M6061T6T0.500W.125	f	1/29/2014	1/28/2014	96.0000	$3.74	0.0000	0	$359.23
	No		6061-T6 RD Tube .500 x .125W	f	96.0000	DESJ02		$359.23	0.0000	0	
			M128084								
	3		M304TR0.250W.049	f	1/29/2014	1/28/2014	20.0000	$0.93	0.0000	0	$18.62
	No		304 Seamless Tubing .250 x .049w	f	20.0000	DESJ02		$18.62	0.0000	0	
			M128084								
	4		M304TR0.500W.035	f	1/29/2014	1/28/2014	200.0000	$0.80	0.0000	0	$159.83
	No		304 RD Tube .500 x .035W	f	200.0000	DESJ02		$159.83	0.0000	0	
			M128084								
	5		M304TR0.750W.049	f	1/29/2014	1/28/2014	200.0000	$1.74	0.0000	0	$347.87
	No		304 RD Tube .750 x .049W	f	200.0000	DESJ02		$347.87	0.0000	0	
			M128084								

Total Received Quantity:	600.0000
Total Qty to Inspect (PO U/M):	0.0000
Total Reject Quantity:	0.0000
Total Receipt Value:	$1,177.78
Total Balance Due Quantity:	0.0000

SHANGHAI CRYSTAL PALACE PIPE CO.,LTD

LAO GANG, PUDONG NEW AREA DISTRICT, SHANGHAI, CHINA

MILL TEST CERTIFICATE

ISO9001:2008 ;PED Material CERTIFICATE (No.:QAC0021058/A) DATE OF ISSUE: 2012/12/15

CUSTOMER: MARMON/KEYSTONE CANADA INC.	CERTIFICATE NO. :2012-9-7-D-1
P.O.NO.: BN3212	ORDER NO. :2012-09-007-D
COMMODITY: STAINLESS STEEL SEAMLESS TUBING.	GRADE : ASTM A213-10a TP304/TP304L
CONDITION: COLD FINISH / SOLUTION TREATED / PICKLED / PLAIN END/ OD POLISHED 400 GRIT	HEAT NO. YT22073

CHEMICAL CONTENTS (WT%)

ELEMENTS	C	Mn	P	S	Si	Ni	Cr		
SPECIFICATION	≤0.035	≤2.00	≤0.040	≤0.030	≤0.75	8.0~11.0	18.0~20.0		
RESULTS (LADLE)	0.021	0.73	0.039	0.006	0.38	8.08	18.10		

PHYSICAL PROPERTIES

Dimensions			Bundle No.	Pieces	Weight (kg)	0.2%YS (Mpa) ≥205	T S (Mpa) ≥515	EL (%) ≥35	FLARING TEST	FLATTENING TEST	HARDNESS HRB ≤80	EDDY CURRENT TEST TO E426 (100%)
O.D (inch)	W.T (inch)	Length (feet)										
0.500	0.035	20	12-10-143	500	797	305	650	63.0	OK	OK	74	OK (DRILLED HOLE)
0.563	0.065	20	12-10-241	50	159	260	690	65.0	OK	OK	75	OK (DRILLED HOLE)

REMARKS:
AS PER ASTM A213-10a/ASME SA213-10
WALL THICKNESS TOLERANCE AS PER ASTM A269-10
IN COMPLIANCE TO NACE MR0175-2003
IC TEST TO ASTM A262 PRACTICE E
SOLUTION HEAT TREATMENT :1050°C X 1.5m/min
NO WELD REPAIR WAS PERFORMED
FREE FROM MERCURY CONTAMINATION
COUNTRY OF ORIGIN: CHINA
MILL TEST CERTIFICATE TO EN 10204/3.1
INVOICE NO: YK-12-12-27

1.WE HEREBY CERTIFY THAT THE MATERIAL DESCRIBED HEREIN HAS BEEN TESTED AND THE TEST RESULTS ARE IN COMPLIANCE WITH THE TERMS OF THE PURCHASE ORDER OR CONTRACT
2.THE CERTIFICATE SHALL NOT BE REPRODUCED, EXCEPT IN FULL, WITHOUT THE WRITTEN APPROVAL OF THE COMPANY.

SHANGHAI CRYSTAL PALACE PIPE CO.,LTD

QC REVIEWED
JAN 14 2013

DING WEI GUO MANAGER OF QUALITY ASSURANCE DEPARTMENT

STS- .500- .035- -304L * YT22073 * 100066 / * BN3212 * 1/14/2013

DART AEROSPACE

Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
Tel: 613 632 9577
Fax: 613 632 1053

PURCHASE ORDER

Purchase Order ID PO22782

Purchase Order Date 1/24/2014
PO Print Date 1/24/2014

Order From : VC-MAR001

MARMON/KEYSTONE CANADA LTD.
290 CHEMIN DU TREMBLAY
BOUCHERVILLE, QC J4B 5X9
CA

Ship To : DART AEROSPACE LTD

1270 ABERDEEN
HAWKESBURY, ON K6A 1K7
CANADA

Contact Name
Vendor Phone 800 361 8142

Ship To Contact
Ship To Phone
Ship Via: TST ground
Ship Acct:

Buyer Chantal Lavoie
Customer POID
Customer Tax # 10127-2607
Terms Net 30
Currency CAD
FOB Destination-Collect

3	M304TR0.250W.049	304 Seamless Tubing .250 x .049w	1/29/2014 Yes 1/29/2014	20.00 f		$0.99	$19.80

MATERIAL: AISI 304/316 SS SEAMLESS ROUND TUBING
AS PER ASTM A213 OR ASME SA213 OR ASTM A269

Line Total: **$19.80**

4	M304TR0.500W.035	304 RD Tube .500 x .035W	1/29/2014 Yes 1/29/2014	200.00 f		$0.85	$170.00

MATERIAL: AISI 304/316 SS SEAMLESS ROUND TUBING
AS PER ASTM A213 OR ASME SA213 OR ASTM A269

Line Total: **$170.00**

5	M304TR0.750W.049	304 RD Tube .750 x .049W	1/29/2014 Yes 1/29/2014	200.00 f		$1.85	$370.00

MATERIAL: AISI 304/316 SS SEAMLESS ROUND TUBING
AS PER ASTM A213 OR ASME SA213 OR ASTM A269

Line Total: **$370.00**

Note:

Marmon/Keystone Canada Inc.
ACIERS SPÉCIALISÉS

290 Chemin du Tremblay
Boucherville QU CAN J4B 5X9
TEL. 514/527-9153
FAX. 450/641-4357

PAGE..: 1
Order : 1142424
Date..: 01/27/2014

PACKING SLIP

SOLD TO:

DART AEROSPACE LTD
1270 ABERDEEN STREET

HAWKESBURY ON CAN K6A 1K7

SHIPPED TO:

DART AEROSPACE LTD
1270 ABERDEEN STREET

HAWKESBURY ON CAN K6A 1K7

SHIP VIA	F.O.B.	SALESPERSON	YOUR ORDER NO.
TST OVERLAND #222212	BOUCHERVILLE	C. Gee	PO22782

	Ordered	Description	Number Pieces	Quantity Shipped	Back Ordered
		Fax all papers to Linda Lacelle 613-632-1053 rev:01/11 GD			
01	20 /FT	STAINLESS STEEL SEAMLESS TUBE SMLS TUBE 316L 1/4 X .049 A213 STS .250 .049 316L Tariff Number: 7304.41.19.90 Cust. part#.: M304TR0.250W.049 HT#.....: 072-1901 Total...	1 1	20/FT 20/FT	✓
02	200 /FT	STAINLESS STEEL SEAMLESS TUBE SMLS TUBE 304L 1/2 X .035 A213 STS .500 .035 304L Tariff Number: 7304.41.19.90 Cust. part#.: M304TR0.500W.035 HT#.....: YT22073 Total...	10 10	200/FT 200/FT	✓
03	200 /FT	STAINLESS STEEL SEAMLESS TUBE SMLS TUBE 304L 3/4 X .049 A213 STS .750 .049 304L Tariff Number: 7304.41.99.90 Cust. part#.: M304TR0.750W.049 HT#.....: YT30540 Total...	10 10	200/FT 200/FT	✓
04	84 /FT	ALUMINUM SMLS TUBE ATS 1.000 .065 D6061 Tariff Number: 7608.20.00.00 Cust. part#.: M6061T6T1.00W065 HT#.....: 17749890 Total...	7 7	84/FT 84/FT	✓
05	96 /FT	ALUMINUM SMLS TUBE ATS .500 .120 D6061 Tariff Number: 7608.20.00.00 Cust. part#.: M6061T6T0.500W.125 HT#.....: F00140746 Total...	8 8	96/FT 96/FT	✓

Packaging:

Total Weight.....: 145.3

Customers.: _____

Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
Tel: 613 632 9577
Fax: 613 632 1053

PURCHASE ORDER

Purchase Order ID PO22782

Purchase Order Date 1/24/2014
PO Print Date 1/24/2014

Order From : VC-MAR001

MARMON/KEYSTONE CANADA LTD.
290 CHEMIN DU TREMBLAY
BOUCHERVILLE, QC J4B 5X9
CA

Ship To : DART AEROSPACE LTD

1270 ABERDEEN
HAWKESBURY, ON K6A 1K7
CANADA

Contact Name		**Buyer**	Chantal Lavoie		
Vendor Phone	800 361 8142	**Customer POID**			
		Customer Tax #	10127-2607		
Ship To Contact		**Terms**	Net 30		
Ship To Phone		**Currency**	CAD		
Ship Via:	TST ground	**FOB**	Destination-Collect		
Ship Acct:					

3	M304TR0.250W.049	304 Seamless Tubing .250 x .049w	1/29/2014 Yes 1/29/2014	20.00 f	X	$0.99	$19.80

MATERIAL: AISI 304/316 SS SEAMLESS ROUND TUBING
AS PER ASTM A213 OR ASME SA213 OR ASTM A269

Line Total: **$19.80**

4	M304TR0.500W.035	304 RD Tube .500 x .035W	1/29/2014 Yes 1/29/2014	200.00 f	X	$0.85	$170.00

MATERIAL: AISI 304/316 SS SEAMLESS ROUND TUBING
AS PER ASTM A213 OR ASME SA213 OR ASTM A269

Line Total: **$170.00**

5	M304TR0.750W.049	304 RD Tube .750 x .049W	1/29/2014 Yes 1/29/2014	200.00 f	X	$1.85	$370.00

MATERIAL: AISI 304/316 SS SEAMLESS ROUND TUBING
AS PER ASTM A213 OR ASME SA213 OR ASTM A269

14/01/28

Line Total: **$370.00**

Note:

Receiving Report

Date: 14/01/28

Batch No: [redacted]

Supplier: MARMON

Dart P/O: [redacted]

Packing Slip: Yes ✓ No ___
Invoice: Yes ___ No ___
Receipt: Cash ___ Cr ___

Release Note Attached: Yes ✓ No ___ N/A ___
Waybill Attached: Yes ___ No ___
Shipment Complete: Yes ✓ No ___ N/A ___
QC6 Inspection ✓ N/A ___
Work Order 10 N/A ✓

Discrepancies

Part Number	Description	Quantity Ordered	Quantity Received	Quantity Returned	Quantity Short	Comments

Initials of receiver (if shipment OK) Level 12 ✓

Production/Admin: 14/01/28
Date
Received/Costing ___
Initial ___

Location ___

H:\FORMS\Purchasing\approved purch\RECREPORT Rev D

Purchase Order Receipt Listing

Thursday, January 30, 2014 10:41:16 AM

All amounts are calculated in domestic currency.

All Vendors PO ID po22782 All Receipt Dates All Line Item Types
All Item ID/GL/WOs All Rec. Employees All Currencies
Grouped by Vendor ID

Purchase Order ID/ Curr Type	Line Nbr/ Insp Req	Project ID	Reference/ Description/ Cert Std	PO U/M / Stock U/M	Required Date Required Qty	Recv Date/ Recv Emp	Recv Qty (PO U/M)	Cost Per Unit/ Recv Value	Inspected Qty/ Rejected Qty (PO U/M)	MRB Qty/ MRB Reject Qty	Book Amt
VendorID\Vendor Name		**VC-MAR001**	**Marmon/Keystone Canada Ltd.**								
PO22782	1		M6061T6T1.000W.065	f	1/29/2014	1/28/2014	84.0000	$3.48	0.0000	0	$292.21
CAD	No		6061T6 RD TUBE 1.00 x .065w M128084	f	84.0000	DESJ02		$292.21	0.0000	0	
	2		M6061T6T0.500W.125	f	1/29/2014	1/28/2014	96.0000	$3.74	0.0000	0	$359.23
	No		6061-T6 RD Tube .500 x .125W M128084	f	96.0000	DESJ02		$359.23	0.0000	0	
	3		M304TR0.250W.049	f	1/29/2014	1/28/2014	20.0000	$0.93	0.0000	0	$18.62
	No		304 Seamless Tubing .250 x .049w M128084	f	20.0000	DESJ02		$18.62	0.0000	0	
	4		M304TR0.500W.035	f	1/29/2014	1/28/2014	200.0000	$0.80	0.0000	0	$159.83
	No		304 RD Tube .500 x .035W M128084	f	200.0000	DESJ02		$159.83	0.0000	0	
	5		M304TR0.750W.049	f	1/29/2014	1/28/2014	200.0000	$1.74	0.0000	0	$347.87
	No		304 RD Tube .750 x .049W M128084	f	200.0000	DESJ02		$347.87	0.0000	0	

material not ship will rec monday Jan 3 2014 cx 14/01/30

Total Received Quantity:	600.0000
Total Qty to Inspect (PO U/M):	0.0000
Total Reject Quantity:	0.0000
Total Receipt Value:	$1,177.78
Total Balance Due Quantity:	0.0000

Marmon/Keystone Canada Inc.
ACIERS SPÉCIALISÉS

290 Chemin du Tremblay
Boucherville QU CAN J4B 5X9
TEL. 514/527-9153
FAX. 450/641-4357

PAGE..: 1
Order : 1142424
Date..: 01/27/2014

PACKING SLIP

SOLD TO:

DART AEROSPACE LTD
1270 ABERDEEN STREET

HAWKESBURY ON CAN K6A 1K7

SHIPPED TO:

DART AEROSPACE LTD
1270 ABERDEEN STREET

HAWKESBURY ON CAN K6A 1K7

SHIP VIA	F.O.B.	SALESPERSON	YOUR ORDER NO.
TST OVERLAND #222212	BOUCHERVILLE	C. Gee	PO22782

	Ordered	Description	Number Pieces	Quantity Shipped	Back Ordered
		Fax all papers to Linda Lacelle 613-632-1053 rev:01/11 GD			
01	20 /FT	STAINLESS STEEL SEAMLESS TUBE SMLS TUBE 316L 1/4 X .049 A213 STS .250 .049 316L Tariff Number: 7304.41.19.90 Cust. part#.: M304TR0.250W.049 HT#.....: 072-1901	1	20/FT	
		Total...	1	20/FT	
02	200 /FT	STAINLESS STEEL SEAMLESS TUBE SMLS TUBE 304L 1/2 X .035 A213 STS .500 .035 304L Tariff Number: 7304.41.19.90 Cust. part#.: M304TR0.500W.035 HT#.....: YT22073	10	200/FT	
		Total...	10	200/FT	
03	200 /FT	STAINLESS STEEL SEAMLESS TUBE SMLS TUBE 304L 3/4 X .049 A213 STS .750 .049 304L Tariff Number: 7304.41.99.90 Cust. part#.: M304TR0.750W.049 HT#.....: YT30540	10	200/FT	
		Total...	10	200/FT	
04	84 /FT	ALUMINUM SMLS TUBE ATS 1.000 .065 D6061 Tariff Number: 7608.20.00.00 Cust. part#.: M6061T6T1.00W065 HT#.....: 17749890	7	84/FT	
		Total...	7	84/FT	
05	96 /FT	ALUMINUM SMLS TUBE ATS .500 .120 D6061 Tariff Number: 7608.20.00.00 Cust. part#.: M6061T6T0.500W.125 HT#.....: F00140746	8	96/FT	
		Total...	8	96/FT	

Packaging:

Total Weight.....: 145.3

Customers.: _____

SHANGHAI CRYSTAL PALACE PIPE CO.,LTD

LAO GANG, PUDONG NEW AREA DISTRICT, SHANGHAI, CHINA

CRYSTAL-PALACE

MILL TEST CERTIFICATE

ISO9001:2008 ;PED Material CERTIFICATE (No.:QAC0021058/A) DATE OF ISSUE: 2012/12/15

CUSTOMER: MARMON/KEYSTONE CANADA INC.	CERTIFICATE NO. :2012-9-7-D-1
P.O.NO.: BN3212	ORDER NO. :2012-09-007-D
COMMODITY: STAINLESS STEEL SEAMLESS TUBING.	GRADE : ASTM A213-10a TP304/TP304L
CONDITION: COLD FINISH / SOLUTION TREATED / PICKLED / PLAIN END/ OD POLISHED 400 GRIT	HEAT NO.: YL22078

CHEMICAL CONTENTS (WT%)

ELEMENTS	C	Mn	P	S	Si	Ni	Cr		
SPECIFICATION	≤0.035	≤2.00	≤0.040	≤0.030	≤0.75	8.0~11.0	18.0~20.0		
RESULTS (LADLE)	0.021	0.73	0.039	0.006	0.38	8.08	18.10		

PHYSICAL PROPERTIES

Dimensions			Bundle No.	Pieces	Weight (kg)	0.2%YS (Mpa) ≥205	T S (Mpa) ≥515	EL (%) ≥35	FLARING TEST	FLATTENING TEST	HARDNESS HRB ≤80	EDDY CURRENT TEST TO E426 (100%)
O.D (inch)	W.T (inch)	Length (feet)										
0.500	0.035	20	12-10-143	500	797	305	650	63.0	OK	OK	74	OK (DRILLED HOLE)
0.563	0.065	20	12-10-241	50	159	260	690	65.0	OK	OK	75	OK (DRILLED HOLE)

REMARKS:
AS PER ASTM A213-10a/ASME SA213-10
WALL THICKNESS TOLERANCE AS PER ASTM A269-10
IN COMPLIANCE TO NACE MR0175-2003
IC TEST TO ASTM A262 PRACTICE E
SOLUTION HEAT TREATMENT :1050°C X 1.5m/min
NO WELD REPAIR WAS PERFORMED
FREE FROM MERCURY CONTAMINATION
COUNTRY OF ORIGIN: CHINA
MILL TEST CERTIFICATE TO EN 10204/3.1
INVOICE NO: YK-12-12-27

1.WE HEREBY CERTIFY THAT THE MATERIAL DESCRIBED HEREIN HAS BEEN TESTED AND THE TEST RESULTS ARE IN COMPLIANCE WITH THE TERMS OF THE PURCHASE ORDER OR CONTRACT
2.THE CERTIFICATE SHALL NOT BE REPRODUCED, EXCEPT IN FULL, WITHOUT THE WRITTEN APPROVAL OF THE COMPANY.

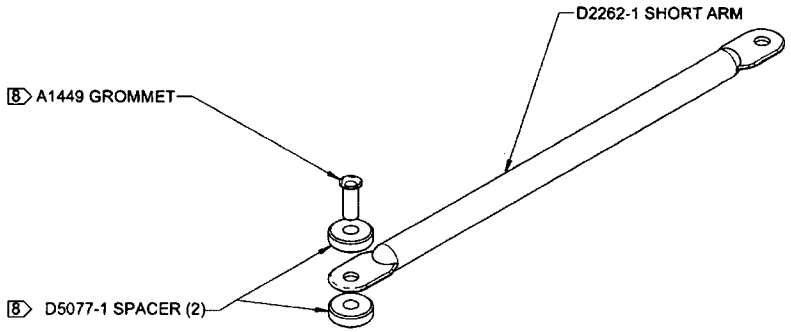
SHANGHAI CRYSTAL PALACE PIPE CO.,LTD

QC REVIEWED
JAN 14 2013

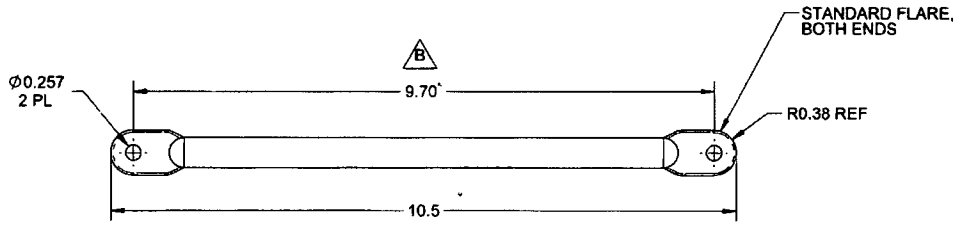
DING WEI GUO MANAGER OF QUALITY ASSURANCE DEPARTMENT

STS- .500- .035- -304L * YL22078 * 100066 * BN3212 * 1/14/2013

ITEM	QTY -041	P/N	DESCRIPTION
	X	D2262-041	SHORT ARM ASSY
1	1	D2262-1	SHORT ARM
2	2	D5077-1	SPACER
3	1	A1449	GROMMET



D2262-041 SHORT ARM ASSY



D2262-1 SHORT ARM

RELEASED 2014 -08- 27

NOTES:
1) MATERIAL: D2262-1: AISI 304/316 SS SEAMLESS ROUND TUBING PER ASTM A213 OR ASME SA213 OR ASTM A269
1/2" OD X 0.035" WALL (REF DART SPEC M304TR0.500W.035)
2) FINISH: D2262-1: POWDER COAT "BLACK SANDTEX" (4.3.5.7) PER DART QSI 005 4.3
D2262-041: NONE
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
6) IDENTIFICATION: IDENTIFY ASSEMBLY WITH DART P/N "D2262-041" USING A REMOVABLE TAG PER DART QSI 044 6.6
7) WEIGHT: 0.07 lbs
8) ASSEMBLE D5077-1 SPACERS (QTY 2), D2262-1 SHORT ARM AND A1449 GROMMET AS SHOWN AND SWAGE GROMMET.

REV.	DESCRIPTION	BY	DATE
B	RE-FORMAT DRAWING, ADD HOLE-TO-HOLE DIMENSION	DB	14.03.12
A	NEW ISSUE	MC	94.08.10

APPROVED

DESIGN	MC	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA
DRAWN	DB	
CHECKED	AP	DRAWING NO. D2262 REV. B
MFG. APPR.	JLM	SHEET 1 OF 1
APPROVED	MP	TITLE SHORT ARM ASSY SCALE NTS
DE APPR.	DS	
DATE	14.03.12	

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